

DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5425-043
Job Sheet 195765


Part No: D5425-043

Job Qty: 1 pcs

Part Name: Float Skidtube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG D5425 REV.B IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.20 AS PER DWG
REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/5/19		0.00	8.24	Skidtubes - 1		TF DD
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	HAAS 4 Axis - B4B	1 pcs	7/5/19		1.00	22.77	HAAS - 1 - B4B		MM. 2019/06/12
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 2	1 pcs	7/5/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		

DART
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Container No: S187888



Part: D5425-043

Job No: 195765

Serial No/Batch: S187888

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/06/19

Plex 5/30/19 10:49 AM Dart.

150 Handfnish - 1-1 Chemical-B4B 1 pcs 7/5/19 0.00 0.24	Handfnish - 1 - 1 - B4B Handfnish - 1 - 2 - B4B Handfnish - 1 - 3 - B4B Handfnish - 1 - 4 - B4B Handfnish - 1 - 5 - B4B Handfnish - 1 - 6 - B4B Handfnish - 1 - 7 - B4B Handfnish - 1 - 8 - B4B Handfnish - 1 - 9 - B4B Handfnish - 1 - 10 - B4B Handfnish - 1 - 11 - B4B Handfnish - 1 - 12 - B4B Handfnish - 1 - 13 - B4B Handfnish - 1 - 14 - B4B Handfnish - 1 - 15 - B4B	Plex 5/30/19 10:49 AM Dart.Guethn.Kimberley
140 QC 8 1 pcs 7/5/19 0.00 0.00	QC 2 - 49 QC 2 - 50 QC 2 - 51 QC 2 - 52 QC 2 - 57 QC 2 - 62 QC 2 - 63 QC 2 - 8 QC 2 - 66 QC 2 - 64 QC 2 - 65 QC 2 - 5 QC 2 - 71 QC 2 - 73 QC 2 - 69 QC 8 - 12 QC 8 - 14 QC 8 - 17 QC 8 - 20 QC 8 - 25 QC 8 - 3 QC 8 - 32 QC 8 - 33 QC 8 - 35 QC 8 - 39 QC 8 - 4 QC 8 - 44 QC 8 - 45 QC 8 - 49 QC 8 - 58 QC 8 - 8 QC 8 - 9 QC 8 - 68 QC 8 - 67 QC 8 - 1 (A) QC 8 - 47 QC 8 - 40 QC 8 - 52 QC 8 - 23 QC 8 - 57	
		QC 2 - 69 QC 2 - 73 QC 2 - 71 QC 2 - 5 QC 2 - 65 QC 2 - 64 QC 2 - 66 QC 2 - 8 QC 2 - 63 QC 2 - 62 QC 2 - 57 QC 2 - 52 QC 2 - 51 QC 2 - 50 QC 2 - 49

5.3 19/06/24

11.11 2019/06/22

B4B					
Handfnish - 1 - 16 -	B4B				
Handfnish - 1 - 17 -	B4B				
Handfnish - 1 - 18 -	B4B				
Handfnish - 1 - 19 -	B4B				
Handfnish - 1 - 20 -	B4B				
Handfnish - 1 - 21 -	B4B				
Handfnish - 1 - 22 -	B4B				
QC 7 - 10		0.00	0.00	7/5/19	1
QC 7 - 13					pcs
QC 7 - 14					
QC 7 - 15					
QC 7 - 17					
QC 7 - 18					
QC 7 - 19					
QC 7 - 2					
QC 7 - 28					
QC 7 - 3					
QC 7 - 30					
QC 7 - 34					
QC 7 - 36					
QC 7 - 37					
QC 7 - 41					
QC 7 - 47					
QC 7 - 48					
QC 7 - 51					
QC 7 - 58					
QC 7 - 59					
QC 7 - 60					
QC 7 - 9					
QC 7 - 68					
QC 7 - 50					
QC 7 - 67					
QC 7 - 40					
QC 7 - 24					
QC 7 - 43					
Skidubes - Bend - B4B		0.50	2.63	7/5/19	1
M&C TF					pcs
QC 5 - 10		0.00	0.00	7/5/19	1
QC 5 - 12					pcs
QC 5 - 17					
QC 5 - 18					
QC 5 - 19					
QC 5 - 22					
QC 5 - 24					
QC 5 - 3					
QC 5 - 43					
QC 5 - 49					
QC 5 - 51					
QC 5 - 58					
QC 5 - 68					
QC 5 - 9					
QC 5 - 50					
Plex 5/30/19 10:49 AM Dart.Guerin.Kimberley					

[illegible]

250 Handfinish - 6-2- Touch Up- B4B		pcs	1	7/5/19	0.00	0.00	Handfinish - 6 - 1 - B4B	QC 5 - 40
Handfinish - 6 - 2 - B4B							Handfinish - 6 - 2 - B4B	QC 5 - 30
Handfinish - 6 - 3 - B4B							Handfinish - 6 - 3 - B4B	QC 5 - 50
Handfinish - 6 - 4 - B4B							Handfinish - 6 - 4 - B4B	QC 5 - 9
Handfinish - 6 - 5 - B4B							Handfinish - 6 - 5 - B4B	QC 5 - 68
Handfinish - 6 - 6 - B4B							Handfinish - 6 - 6 - B4B	QC 5 - 58
Handfinish - 6 - 7 - B4B							Handfinish - 6 - 7 - B4B	QC 5 - 51
								QC 5 - 49
								QC 5 - 43
								QC 5 - 3
								QC 5 - 24
								QC 5 - 22
								QC 5 - 19
								QC 5 - 18
								QC 5 - 17
								QC 5 - 12
								QC 5 - 10
240 QC 5		pcs	1	7/5/19	0.00	0.00	Skidubes - 7 - B4B	QC 7 - 43
							Skidubes - 6 - B4B	QC 7 - 24
							Skidubes - 5 - B4B	QC 7 - 40
							Skidubes - 4 - B4B	QC 7 - 67
							Skidubes - 3 - B4B	QC 7 - 50
							Skidubes - 2 - B4B	QC 7 - 68
							Skidubes - 1 - B4B	QC 7 - 9
230 Skidubes - 3 - B4B		pcs	1	7/5/19	0.00	8.24	QC 7 - 60	QC 7 - 59
							QC 7 - 58	QC 7 - 51
							QC 7 - 48	QC 7 - 47
							QC 7 - 41	QC 7 - 37
							QC 7 - 36	QC 7 - 34
							QC 7 - 30	QC 7 - 28
							QC 7 - 3	QC 7 - 2
							QC 7 - 19	QC 7 - 18
							QC 7 - 17	QC 7 - 15
							QC 7 - 14	QC 7 - 13
							QC 7 - 10	
220 QC 7		pcs	1	7/5/19	0.00	0.00		

[illegible]

QC 14 - 2					
QC 14 - 34					
QC 14 - 41					
QC 14 - 51					
QC 14 - 58					
QC 14 - 59					
QC 14 - 9					
QC 14 - 68					
QC 14 - 40					
QC 14 - 19					
QC 14 - 43					
QC 14 - 24					
282 Outsource - 11 - Paint	1	7/5/19			
ATE003-VC	2				
Packaging 2 - 1 - B4B	1	7/5/19	0.00	0.00	
Packaging 2 - 2 - B4B					
Packaging 2 - 3 - B4B					
Packaging 2 - 5 - B4B					
Packaging 2 - 4 - B4B					
Packaging 2 - 6 - B4B					
Packaging 2 - 7 - B4B					
Packaging 2 - 8 - B4B					
Packaging 2 - 9 - B4B					
Packaging 2 - 10 - B4B					
Packaging 2 - 11 - B4B					
Packaging 2 - 12 - B4B					
Packaging 2 - 13 - B4B					
Packaging 2 - 14 - B4B					
Packaging 2 - 15 - B4B					
Packaging 2 - 16 - B4B					
Packaging 2 - 17 - B4B					
Packaging 2 - 18 - B4B					
Packaging 2 - 19 - B4B					
Packaging 2 - 20 - B4B					
Packaging 2 - 21 - B4B					
Packaging 2 - 22 - B4B					
Packaging 2 - 23 - B4B					
Packaging 2 - 24 - B4B					
Packaging 2 - 25 - B4B					
Packaging 2 - 26 - B4B					
Packaging 2 - 27 - B4B					
Packaging 2 - 28 - B4B					
Packaging 2 - 29 - B4B					
Packaging 2 - 30 - B4B					
Packaging 2 - 31 - B4B					
Packaging 2 - 32 - B4B					
Packaging 2 - 33 - B4B					
Packaging 2 - 34 - B4B					
Packaging 2 - 35 - B4B					
Packaging 2 - 36 - B4B					
QC 6 - 9	1	7/5/19	0.00	0.00	
QC 6 - 68					
QC 6 - 61					
QC 6 - 40					
Handfinish 4 - 1 - B4B	1	7/5/19	0.00	0.24	
Handfinish 4 - 10 - B4B					
Handfinish 4 - 11 - B4B					
Handfinish 4 - 12 - B4B					
286 QC 6	1	7/5/19			
280 Handfinish - 4-1-Assembly-B4B	1	7/5/19			
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Handfinish - 4 - 13 - B4B				
Handfinish - 4 - 14 - B4B				
Handfinish - 4 - 15 - B4B				
Handfinish - 4 - 2 - B4B				
Handfinish - 4 - 3 - B4B				
Handfinish - 4 - 4 - B4B				
Handfinish - 4 - 5 - B4B				
Handfinish - 4 - 6 - B4B				
Handfinish - 4 - 7 - B4B				
Handfinish - 4 - 8 - B4B				
Handfinish - 4 - 9 - B4B				
QC 5 - 10		0.00	0.00	7/5/19
QC 5 - 12				
QC 5 - 17				
QC 5 - 18				
QC 5 - 19				
QC 5 - 22				
QC 5 - 24				
QC 5 - 3				
QC 5 - 43				
QC 5 - 49				
QC 5 - 51				
QC 5 - 58				
QC 5 - 68				
QC 5 - 9				
QC 5 - 50				
QC 5 - 30				
QC 5 - 40				
Packaging 3 - 1 - B4B		0.00	0.00	7/5/19
Packaging 3 - 2 - B4B				
Packaging 3 - 3 - B4B				
Packaging 3 - 4 - B4B				
Packaging 3 - 5 - B4B				
Packaging 3 - 6 - B4B				
Packaging 3 - 7 - B4B				
Packaging 3 - 8 - B4B				
Packaging 3 - 9 - B4B				
Packaging 3 - 10 - B4B				
Packaging 3 - 11 - B4B				
Packaging 3 - 12 - B4B				
Packaging 3 - 13 - B4B				
Packaging 3 - 14 - B4B				
Packaging 3 - 15 - B4B				
Packaging 3 - 16 - B4B				
Packaging 3 - 17 - B4B				
Packaging 3 - 18 - B4B				
Packaging 3 - 19 - B4B				
Packaging 3 - 20 - B4B				
Packaging 3 - 21 - B4B				
Packaging 3 - 22 - B4B				
Packaging 3 - 23 - B4B				
Packaging 3 - 24 - B4B				
Packaging 3 - 25 - B4B				
Packaging 3 - 26 - B4B				
Packaging 3 - 27 - B4B				
Packaging 3 - 28 - B4B				
Plex 5/30/19 10:49 AM Dart Guerin, Kimberley				

310 Packaging 3-1 - Stock - B4B
1 pcs

300 QC 5
1 pcs

DAS
40
JUL 26 2019
9-89

320 QC 21 - SA		1	pcs	7/5/19	0.00	0.00	
Packaging 3 - 29 - B4B							
Packaging 3 - 30 - B4B							
Packaging 3 - 31 - B4B							
Packaging 3 - 32 - B4B							
Packaging 3 - 33 - B4B							
Packaging 3 - 34 - B4B							
Packaging 3 - 35 - B4B							
Packaging 3 - 36 - B4B							
QC 21 - SA - 21							
QC 21 - SA - 70							
QC 21 - SA - 53							
DUE JUL 3 0 2019							
DUE JUL 3 0 2019							

Part Op 110 - 1-Cut tube to finished length as per Dwg. 2-Debur ends as per Dwg.
Descriptions: 120 - 1-Machine as per Dwg. and Folio FB536 DWG REV: FOLIO REV: 2-Debur as per Dwg.

140 - (QC8- Inspect parts - second check)
150 - 1-Scrub inside of tube with medium scotchbrite.
160 - (QC7-Inspect Chemical Conversion Coat)
170 - 1-Bend Aft end of tube as per Dwg. and Folio
Bending mandrel DT 10328 at 12.0" from fwd end. Use buggy A,B,C to stabilize tube. HEIGHT 7.430 3-Record
180 - (QC5- Inspect part completeness to step on W/O)
190 - 1-Drill remaining holes of DETAIL M, N, P USING DT10340 A,B,C. 2-Open holes to finished size as per Dwg. 3-
Debur holes per QSI002 section 4.2.3 and blow out all chips from inside of tube.
200 - (QC5- Inspect part completeness to step on W/O)
220 - (QC7-Inspect Chemical Conversion Coat)
230 - 1-Wet install crossbolt spacers of Section G-G. Swage to 0.437 as per Dwg. PRIMER B 50860
Time: 11:00m Finish Time: 5:00pm
crossbolt spacers of Section F-F to 0.313 as per Dwg. 3-Trim / Grnd flush, deburr. 4-Identify per QSI 044 6.1
240 - (QC5- Inspect part completeness to step on W/O)
250 - (Touch up alodine) ***DO NOT SUBMERGE TUBE IN DEOXIDIZER***
260 - (QC7-Inspect Chemical Conversion Coat)
270 - (Spray Paint / NDT Room) ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-
PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5189559 2-PAINT AS PER DWG AND
QSI005 4.2.2.4 PAINT BATCH: 5192331 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT
284 - C OF C IS REQUIRED
290 - (Assemble as per dwg) 1-Install FWD and AFT cap seal with sikaflex-241 / 291 B516342 Exp: 14-12-8
Start time: Finish time: 2-Coat all exposed hardware with LPS Procyon. Remove any
excess off with MEK degreaser. A/R LPS Procyon B 51132 68
300 - (QC5- Inspect part completeness to step on W/O)
310 - (Identify as per dwg & Stock Location)
320 - (QC21-Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation
D6028-195	Crossbolt Spacer	1 pcs (1 ea)	110-Skidtubes - 1
D5518-1	Crossbolt Spacer	18 pcs (18 ea)	230-Skidtubes - 3 - B4B
D5512-1	Crossbolt Spacer	12 pcs (12 ea)	230-Skidtubes - 3 - B4B
AN3C5A	Bolt	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B
D3672-1	Washer, Phenolic	6 pcs (6 ea)	290-Handfinish - 4-1-Assembly-B4B
D5483-041	Tow Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B
D5484-041	Aft Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B
NAS1149C0332R	Washer	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B

Container

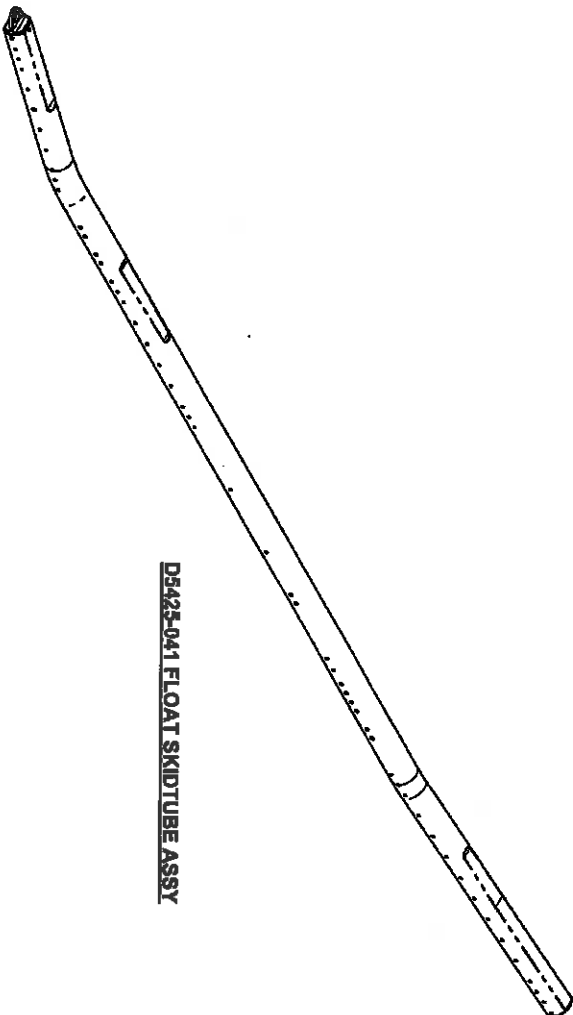
011091

5192144
5187624
5183703
5187624
5192144
5164009
5151154
5200344
5138131

Job Allocations			
Operation	Component Part	Required	Inventory
110-Skidtubes - 1	D6028-195	1	0
230-Skidtubes - 3 - B4B	D5612-1	12	42
290-Handfinish - 4-1-Assembly-B4B	D5518-1	18	272
	AN3C5A	6	1,224
	D3672-1	6	1,727
	D5483-041	1	10
	D5484-041	1	9
	NAS1149C0332R	6	3,344
Part Specifications			
Specifications could not be found.			
Allocated			

Plex 5/30/19 10:49 AM Dart.Guerin.Kimberley

QTY	PN	DESCRIPTION
X	D5425-041	FLOAT SKIDTUBE ASSY
8	D5672-1	WASHER
1	D5425-1	FLOAT SKIDTUBE
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
37	D5518-1	CROSSBOLT SPACER
6	ANGCSA	BOLT
6	WAS1149C0332R	WASHER



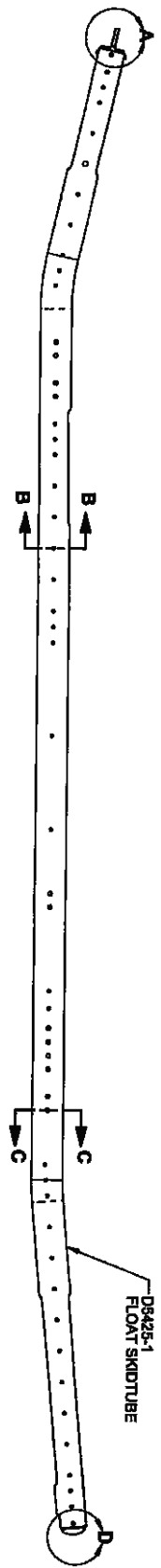
D5425-041 FLOAT SKIDTUBE ASSY

RELEASED
2018 AUG 16
E.O. 12812

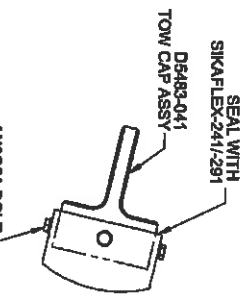
B		CHANGE HOLE SIZE TO REMOVE OFF-AXIS SWAGING IN SHEETS 5 AND 8 (REVISED 10/11) PICTORIAL UPDATE DUE TO CHANGES IN D5425-1.		NO	18.02.05
A		NEW ISSUE		NO	17.07.10
DESIGN	NO	DESCRIPTION	DART AEROSPACE USA, INC.		
DRAWN	NO	CHECKED	ZF	BY	DATE
MFG. APPR.	DD	APPROVED	NO	TITLE	
DE APPR.	D5-1	412 FLOAT SKIDTUBE			
DATE	18.02.05	REV. B			
		SHEET 1 OF 10			
		SCALE			
		MFG.			

APPROVED

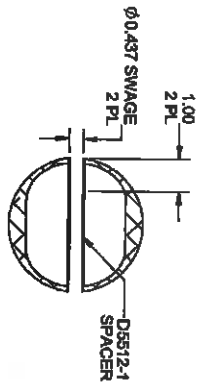
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DS425-041 FLOAT SKIDTUBE ASSY

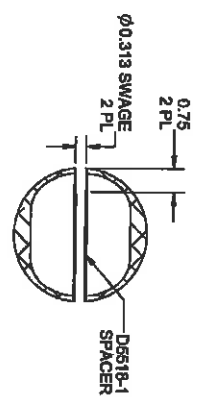


DETAIL A
SCALE 4X



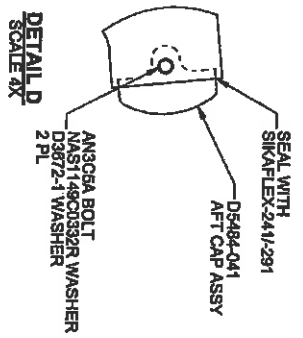
AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.608 HOLES ONLY:
1. WET INSTALL D5612-1 SPACER PER QSI 002
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION C-C
SCALE 4X
12 PL



AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.377 HOLES ONLY:
1. INSERT D5618-1 SPACER
2. SWAGE TO Ø0.313 X 0.75 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION B-B
SCALE 4X
37 PL



DETAIL D
SCALE 4X

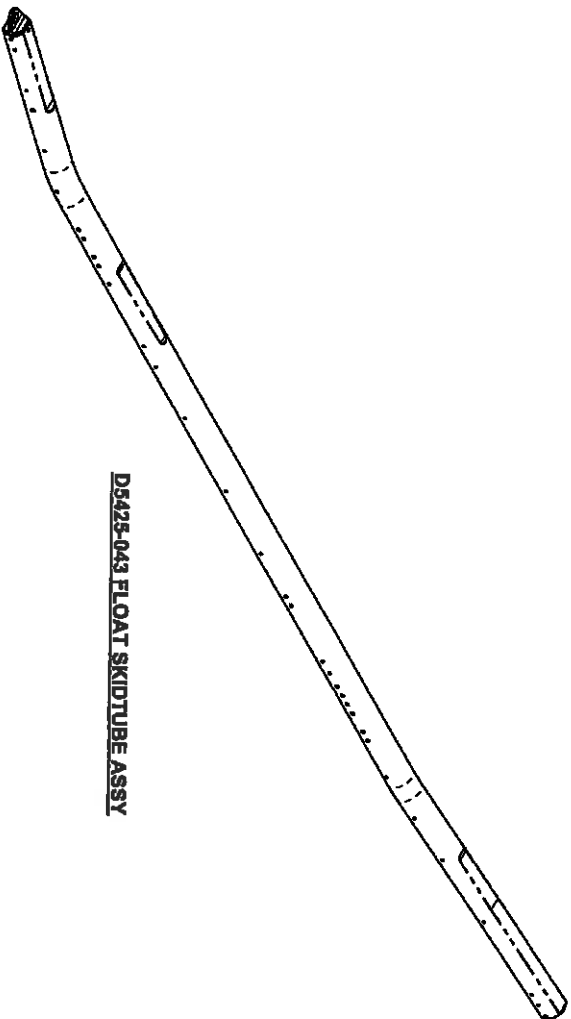
- NOTES:**
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1, 3.3
PAINT PER DART QSI 005 4.2.2, 4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 54.5lbs
8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCOYON"

APPROVED

DESIGN	NO	NO	DART AEROSPACE USA, INC.
DRAWN			EUGENE, OR
CHECKED			
MFG. APPR.	ZF		
APPROVED	DD		
DE APPR.	DS		
DATE	18.02.05		
TITLE	412 FLOAT SKIDTUBE		
SCALE	N/A		
REVISIONS			
REV. B			
SHEET 7 OF 10			
DATE			
DATE			

RELEASED
2018 AUG 16

QTY	PN	DESCRIPTION
043		
X	D5425-043	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-3	FLOAT SKIDTUBE (DART TRIBAG)
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5612-1	CROSSBOLT SPACER
18	D5618-1	CROSSBOLT SPACER
6	AN805A	BOLT
6	NAS1149C0332R	WASHER

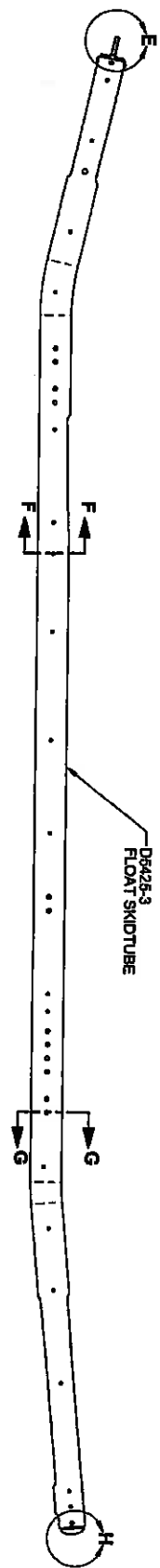


D5425-043 FLOAT SKIDTUBE ASSY

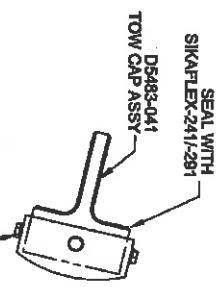
APPROVED

DESIGN	NO	NO	DART AEROSPACE USA, INC.
DRAWN	NO	NO	EUGENE, OR
CHECKED	ZF	DD	D5425
MFG. APPR.	DD	DD	412 FLOAT SKIDTUBE
APPROVED	NO	DD	412 FLOAT SKIDTUBE
DATE	18.02.05	DD	412 FLOAT SKIDTUBE

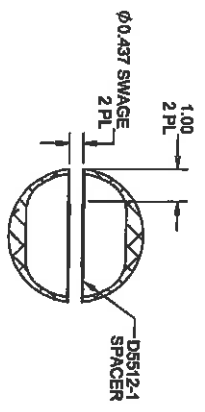
RELEASED
2018 AUG 16



D5425-043 FLOAT SKIDTUBE ASSY

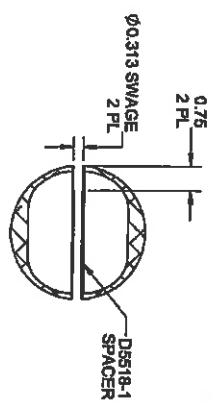


DETAIL E
SCALE 4X



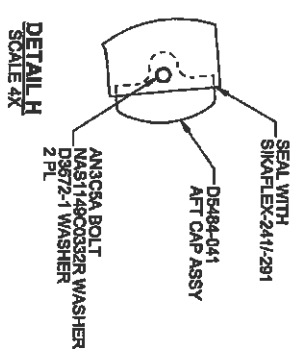
SECTION G-G
SCALE 4X
12 PL

AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.308 HOLES ONLY:
1. WET INSTALL D5512-1 SPACER PER QSI 002
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002



SECTION F-F
SCALE 4X
18 PL

AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.377 HOLES ONLY:
1. INSERT D5518-1 SPACER
2. SWAGE TO Ø0.313 X 0.75 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002



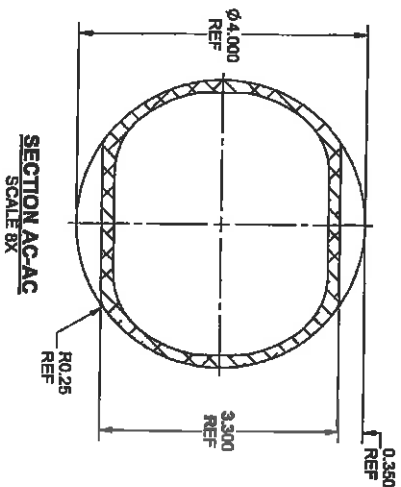
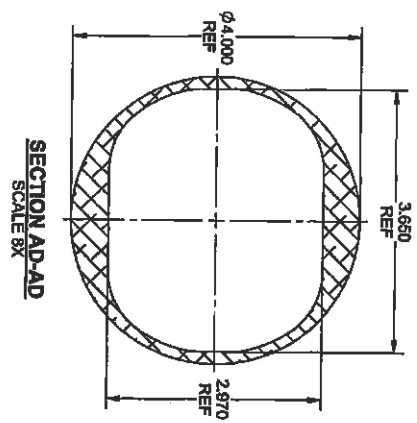
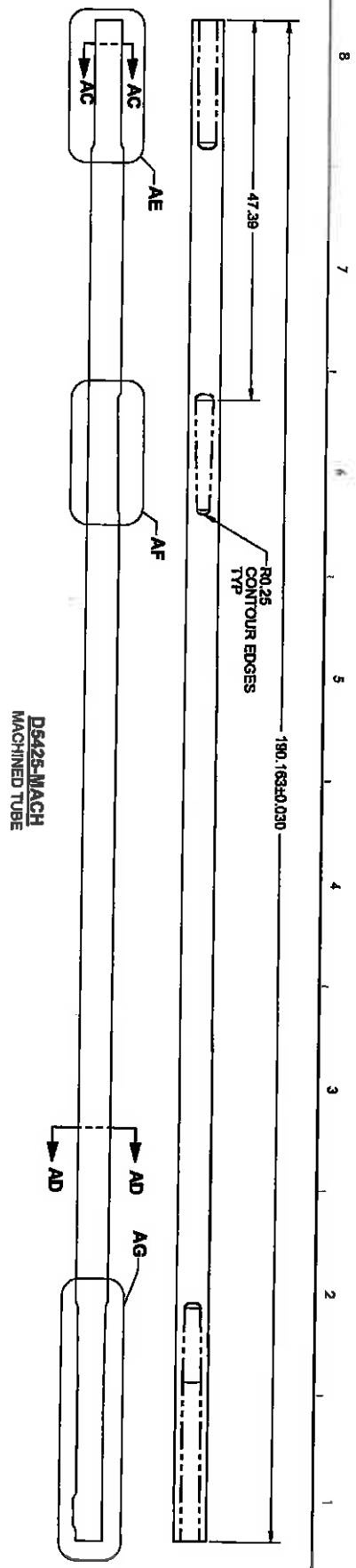
DETAIL H
SCALE 4X

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2, 1.5.3
PAINT PER DART QSI 005 4.2.2.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 56.3lbs
 - 8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"

APPROVED

DESIGN	NO	NO	DART AEROSPACE USA, INC.
DRAWN	NO	NO	ENGINEER OR
CHECKED	ZF	DD	REV. B
MFG. APPR.	DD	DD	D5425
APPROVED	NO	NO	TITLE
DATE	18.02.05	18.02.05	412 FLOAT SKIDTUBE
DE APPR.	DS	DS	SCALE
			1/10

RELEASED
2018 AUG 16

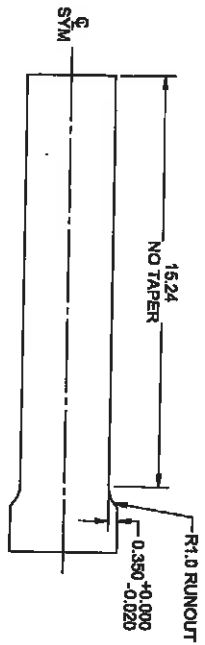


- NOTES:
- 1) MATERIAL: MAKE FROM D8028-196 EXTRUSION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER PART QSI D18 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 82.57 lbs
 - 8) NO SHARP CORNERS, MIN RADIUS 0.125"

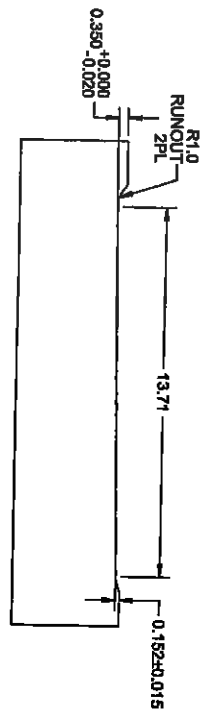
APPROVED

DESIGN	NO	NO	DART AEROSPACE USA, INC.
DRAWN	NO	NO	EXTEND OR
CHECKED	ZF	NO	REV. B
MFG. APPR.	DO	NO	SHEET 9 OF 10
APPROVED	NO	NO	SCALE
DIE APPR.	DS	NO	INTS
DATE	18.02.05		

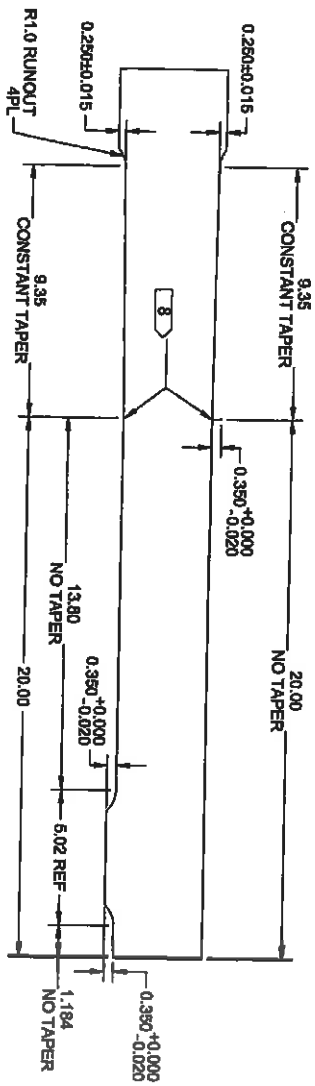
RELEASED
2018 AUG 16



DETAIL AE
SCALE 3X



DETAIL AF
SCALE 3X



DETAIL AG
SCALE 3X

APPROVED

DESIGN	NO	DATE	DRAWING NO.	REV. B
DRAWN	NO		D5425	
CHECKED	ZF			
MFG. APPR.	DD			
APPROVED	NO			
DE APPR.	DS			
DATE	18.02.05			
412 FLOAT SKIDTUBE				
SCALE 10 OF 40				
MFG				

RELEASED
2018 AUG 16

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: 155765

Part No. 05425-043

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☒

DEPARTMENT/PROCESS

Skid-tube Machining ☒ Large Fab ☐ Cross tube Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering Water Jet Supplier Quality ☐

Date: 12/17/13

Sequence #: _____

QTY Affected: (1)

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Flect & Gth spars are sized ~ 0.980"

Acceptable. No effect on design.

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐

Other/Details: _____

- 0266

H:\FORMS\Quality Assurance\approved QA\inspection sheet revB

DART AEROSPACE LTD		Work Order:		Description: 412 FRONT SKIDTUBE		Part Number: D5425-3		Page 1 of 1	
Inspection Dwg: D5425		Rev: B		INSPECTION SHEET					
Drawing	Dimension	Tolerance	Actual	Dimension	Accept	Reject	Method of Inspection	Comments	
0.500	+/- .010	498	✓				Verifier		
2.490	+/- .010	2792	✓				Verifier		
10.490	+/- .010	10788	✓				Verifier		
14.490	+/- .010	14798	✓				Verifier		
43.120	+/- .010	43110	✓				Tape		
44.840	+/- .010	44860	✓						
48.34	+/- .010	48375	✓						
60.34	+/- .010	60360	✓						
64.34	+/- .010	64360	✓						
74.360	+/- .010	74360	✓						
123.328	+/- .010	123318	✓						
125.84	+/- .010	125860	✓						
129.34	+/- .010	129360	✓						
131.12	+/- .010	131110	✓						
134.67	+/- .010	134610	✓						
136.34	+/- .010	136360	✓				Tape		
0.500	+/- .010	498	✓				Verifier		
2.690	+/- .010	2690	✓				Verifier		
4.69	+/- .010	4695	✓				Verifier		
18.69	+/- .010	18687	✓				Verifier		
15.24	+/- .030	1524	✓				Top		
8.10	+/- .100	810	✓				Top		
0.350	+/- .020	340	✓				Top		
0.350	+/- .020	341	✓				Top		
8.10	+/- .100	810	✓				Top		
13.41	+/- .030	13.725	✓				Tape		
0.152	+/- .015	141	✓				Tape		
0.250	+/- .015	243	✓				Tape		
9.35	+/- .030	935	✓				Tape		
0.350	+/- .020	348	✓				Tape		
20.00	+/- .030	2000	✓				Tape		
0.250	+/- .015	244	✓				Tape		

Engineering Approval: (if necessary)

Date:

Measured by: *MM*

Checked by: *64*

Date: *2019/01/22 9:59*

QC Inspector: *MM*

Date:

Rev B 14.07.31 Change

Revised by

KJ

Approved

Rev	B	Date	14.07.31	Change	New locks
Engineering Approval: (if necessary) Date: 19/06/23					
Date:					

Measured by:	<i>mm</i>	Checked by:	<i>mm</i>	Date:	<i>19/06/23</i>	QC Inspector:	Date:
Engineering Approval:	(if necessary)						

[illegible]

INSPECTION SHEET

DART AEROSPACE LTD		Description: 412 FLOAT SKIDTUBE		Inspection Dwg: D5425 Rev: B	
Work Order:		Part Number:		D5425-3	
Page 1 of 1		INSPECTION SHEET			